



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D407-559-113
Job Sheet 180959



Part No: D407-559-113

Job Qty: 1 ea

Part Name: 206L Series/407 Bearpaws - Large



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV L SHEET 7 IPP RevA: New issue DD 09.10.29 verified by:EC IPP RevB: ECN09-698p DD 09.11.03
verified by:EC IPP RevC: as per revision K DD 09.11.24 verified by:EC IPP Rev:D 10.05.27 per ECN10-575
DD verf:EC IPP REV:E 11-04-11 PER INN REV L JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Stores/Pkg-2		<i>JRB</i> AUG 10 2018
160	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging1-4		<i>JRB</i> AUG 14 2018
170	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC4		<i>JRB</i> AUG 14 2018
175	DC	1 pcs	8/3/18	8/3/18	0.00	0.00	DC		<i>JRB</i> AUG 14 2018
180	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-2		<i>JRB</i> AUG 14 2018
190	QC21-FG	1 Ea	8/3/18	8/3/18	0.00	0.00	QC21		<i>JRB</i> AUG 14 2018

Part Op 175 - Photocopy bluefile and create labels per PPPD407-559-113 CHG003
Descriptions: 180 - Identify and pack for shipping as per PPPD407-559-113

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5071600X5 5060054X3
AN4C20A	Bolt	16 Ea (16 ea)	90-Start up Operation	FM136554X14 5039735X2
AN4C21A	Bolt	16 Ea (16 ea)	90-Start up Operation	FM1365860
D2274	Radius Block	16 Ea (16 ea)	90-Start up Operation	5089982
D3456-1	Washer	8 Ea (8 ea)	90-Start up Operation	5019335
D4011-1	Clamp, Short	8 Ea (8 ea)	90-Start up Operation	5083396
D4011-5	Clamp, Short	8 Ea (8 ea)	90-Start up Operation	5132223
D4012-1	Cushion	8 Ea (8 ea)	90-Start up Operation	5153231
D4355-1	Bearpaw	2 Ea (2 ea)	90-Start up Operation	5043225
D4360-041	Wearplate Assembly	2 Ea (2 ea)	90-Start up Operation	5043715
MS21043-4	Nut	24 Ea (24 ea)	90-Start up Operation	5089277
NAS1149D0463J	Washer	16 Ea (16 ea)	90-Start up Operation	5089299

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4C11A	8	105	0
	AN4C20A	16	70	0
	AN4C21A	16	38	0
	D2274	16	235	0
	D3456-1	8	288	0
	D4011-1	8	158	0
	D4011-5	8	25	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval					
Description Work		Disposition							
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S101234 Part: D407-559-113 Job No: 180959 Serial No/Batch: S101234 Revision: Inspector: Exp Date: Instructions: TC STC SH92-17 Issue 7 Ref: FAI/STC SH1031NE 01/11/09, LBA GER		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐								
OTHER : _____		<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> <td style="width:50%;"> Misaligned/off center ☐ </td> </tr> </table>				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	Misaligned/off center ☐		
Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	Misaligned/off center ☐								

D4012-1	8	335	0
D4355-1	2	4	0
D4360-041	2	5	0
MS21043-4	24	1,646	0
NAS1149D0463J	16	11,622	0

Part Specifications

Specifications could not be found.

Plex 7/18/18 10:53 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

32.7 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

REFERENCE ONLY

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32-00-00

Revision: 5

Change Record

PAGE 1 OF 1

Part Number: D407-559-113

Description: BEARPAW INSTALLATION

[illegible]